Work Orde Thursday, May			44 				-				Page 1
Item ID: Revision ID: Item Name:	D3463-042 Step Weldmen	t Assembly	Section 1	Accept					Setup Sta		
Start Date: Required Date: Reference:	5/26/2011 : 6/3/2011	Start Qty: 2.00 Req'd Qty: 2.00		e George	Cust Item I Customer:	D:					
Approvals:	Process Pla	n:	Date://-05-20	Tooling: SPC (Y/N):		ate:		F	Run Sta		18118 186 188 1886 18118 188 188 1886
Sequence ID/ Work Center II	D ′	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr		ision Nbr			, , , ,						
D3463	Rev	В	The state of the s								
100 Large Fab		Large Fab		0.00				R	11-	8-16	(I)
Large Fab			embly as per dwg D3463 usin	g DT8875							
110 QC Quality Control		QC9- Inspect visual p	er QS1004- Fusion Welds	0.00			ζ	Pluo	3 · (7		· -
120 QC Quality Control	4	QC5- Inspect part cor	npleteness to step on W/O	0.00	alvel 17			40			· -

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W/O:				WO	RK ORDER	CHANGES			· · · · · · · · · · · · · · · · · · ·		
DATE	STEP		PRO	CEDURE CHAI	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR	NC	R: Yes		A :	Date:				
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NCR:			W	ORK ORDE	R NON-CON	FORMANC	E (NCI	3)			
DATE	STEP	Description of	Description of NC		Corrective Action Se			Verific	ation	Approval	Approval
DATE	SIEP	Section A		Initial Chief Eng	Action Des Chief E	cription ng	Sign of Date	& Secti		Chief Eng	QC Inspector
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Work Order ID 70071 Thursday, May 26, 2011 11:14:34 AM Item ID: D3463-042 Accept Setup Start **Revision ID:** Stop Item Name: Step Weldment Assembly **Start Date:** 5/26/2011 Start Oty: 2.00 **Cust Item ID:** Req'd Qty: 2.00 Required Date: 6/3/2011 **Customer:** Reference: Run Start **Approvals:** Process Plan: Date: **Tooling:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Reject Set Up/ **Tool ID** Tool # Plan Accept Reject Work Center ID Qty **Description Run Hours** Code Number **Qty** 130 White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel 0.00 Powdercoat Memo Powder Coating 1- Mask areas indicated on dwg Wing Walk as per dwg QSI005 4.4 Batch_

140

HandFinish

Hand Finishing

Quality Control

150

QC

Memo

QC3- Inspect Part Finish

Memo

0.00

0.00

0.00

Page 2



Insp. Stamp

2 BL 128-22

	oopaot								
W/O:			M	ORK ORDER CHANGE	S				
DATE	STEP	PROC	EDURE CH	EDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	·	PAR #:	_ Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date: _	
		esolution:						`	
NCR:	** ** ** ** * * * * * * * * * * * * *	W	ORK OR	DER NON-CONFORMAN	ICE (NC	R)			
DATE	STEP	Description of NC	Corrective Action Section B			Verific	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	ion C	Chief Eng	QC Inspector
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Work Order ID 70071

Thursday, May 26, 2011 11:14:34 AM



Page 3

Item ID:

D3463-042

Accept

Setup Start

Stop



Revision ID:

Item Name:

Step Weldment Assembly

Start Date:

5/26/2011

Start Qty: 2.00

Required Date: 6/3/2011

Req'd Qty: 2.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Date: _____

Tooling:

SPC (Y/N):

Set Up/

Date:

Date:

Start Run

Stop



Sequence ID/ **Work Center ID**

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

0.00

Tool ID Run Hours

0.00

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

170

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

	oopaoo									
W/O:			WC	ORK ORDER CHANG	GES					
DATE	STEP	PRO	CEDURE CHA	NGE	Ву			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	_ Fault Cate	gory:	NCR	: Yes N	lo DQ	٨:	Date: _	
	R	esolution:	Dispositio	n:	QA: N/C Closed: Date:					
NCR:			ORK ORD	ER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC	Corrective Action Section B			Verifica		ation	Approval	Approval
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'Picklist Print

Thursday, May 26, 2011 11:14:45 AM

Work Order ID: 70071

Parent Item:

D3463-042

Parent Item Name: Step Weldment Assembly



Start Date: 5/26/2011

Required Date: 6/3/2011

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:	IPP REV.	Α	05.

5.11.18

new issue

EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-806 SS DOWEL PIN 1" LONG		Purchased	No			100	Each	92.0000	2 	4	11-9	8-16	
				Location		Loc	<u>Oty</u>	Loc Code					
				ST			92						
D3453-3	II 6 10 11	Manufactured	No	-	117606	100	92 . · Each	0.0000	1	72			"
Clevis				-	70854	LY				FL	11-8	-/6	
D3453-5		Manufactured	No			100	Each	15.0000	1 	2 /2	/ /1.06.	02	
Tiug				Location		<u>Loc</u>	<u>Oty</u>	Loc Code					

	i
Plug	
D3463-1	
Arm	.,
D3463-3	
	••

		WA023
Manufactured	No	59204
		1372034 X
Manufactured	No	

L	oc Oty	Loc Code
	15	
	15	
100	Each	0.0000

Each



2		
EL	11-8-16	

D 11-8-16

m			

Loc Qty	Loc Code
26	

26.0000

Location WA025

26

100

Step

	Johan											
W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE				ı	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			**************************************					, , , , , , , , , , , , , , , , , , , ,				
Part No:		PAR #:	#: Fault Category:			NCR: Yes No DQA: Date:						
			Disposition: QA									
NCR:		W	ORK OR	DER NON	-CONFORMA	NCE (NCR)					
DATE	STEP	Description of NC	Corrective Action Section B					Verific	ation	Approval	Approval	
DAIL	SILF	Section A	Initial Chief Eng	Actio	on Description Chief Eng		Sign & Date	Section C		Chief Eng	QC Inspector	
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				·								

Picklist Print

Thursday, May 26, 2011 11:14:46 AM

Page 2

Work Order ID: 70071

Parent Item:

D3463-042

Parent Item Name: Step Weldment Assembly



Start Date: 5/26/2011

Required Date: 6/3/2011

Start Qty: 2.00

Required Qty: 2.00

D3463-5



End Cap

D3463-7

Drag Arm

Manufactured No

Manufactured

100

100

Each

13.0000

Loc Code

Loc Code

DZ 11-8-16

Location WA004

Loc Qty 13 13 Each

3.0000

Q 11-8-16

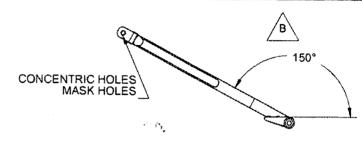
Location Loc Qty WA025 59199 62813 70857

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W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No					NCR: Yes No DQA: Date:							
	R	esolution:			•			Date: _				
NCR:		V	WORK ORI	DER NON-CONFORMA	NCE (NCF	R)			:			
DATE	STEP	Description of NC		Corrective Action Section B			Verification		Approval			
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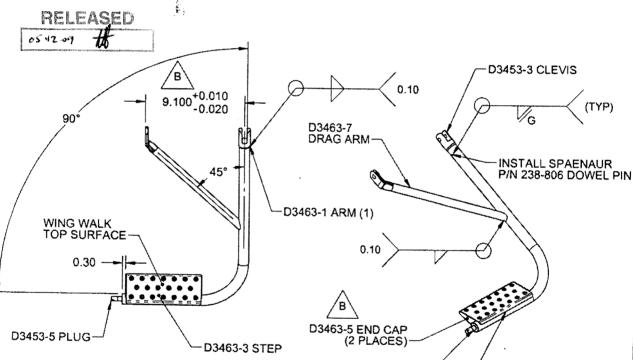


DESIGN DRAWN BY RF		1	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECK	ED #	APPROVED #	DRAWING NO. D3463	REV. B			
05.12.05			STEP WELDMENT	SCALE 1:8			
A	0:	5.09.20	NEW ISSUE				
В	0:	5.12.05	REVISE DIM.; D3463-5 WAS D3463-5	5F			

INSTALL P/N 238-806 DOWEL PIN (TYP) G MASK THREAD **AREA** 1.045 -



(TYP)



SHOP COPY ETURN TO

ENGINEERING

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WITHOUT NOTICE WCRK Q NO.

NOTES:

1) WELD PER DART QSI 004
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

D3463-042 STEP WELDMENT ASSEMBLY D3463-041 OPPOSITE

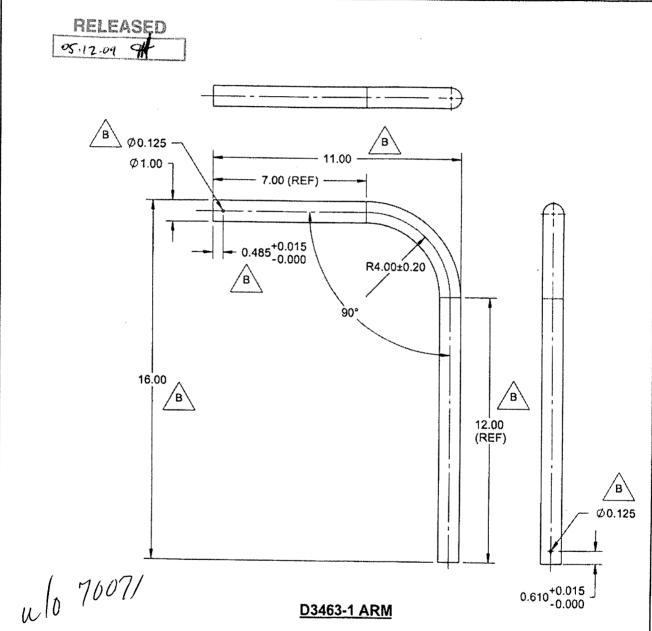
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DATE	STEP Description of NC Section A	Description of NC		n B	Verifi	cation	Approval		
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECKED	APPROVED #	D3463	REV. B SHEET 2 OF 4			
DATE 05.1	12.05	STEP WELDMENT	SCALE 1:4			



NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120) 2) FINISH: NONE 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

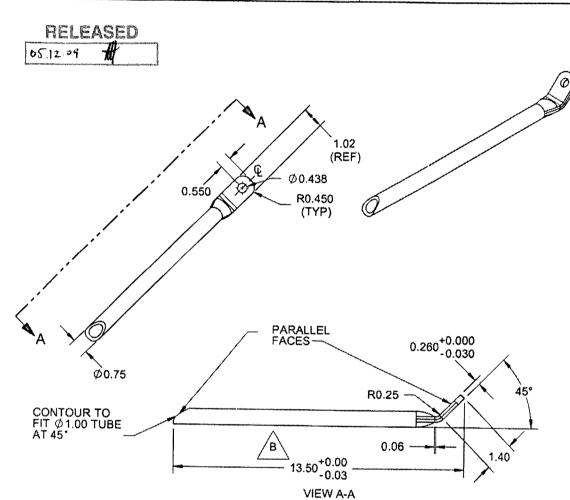
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W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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DATE	STEP Description of NC Section A			Corrective Action Section		Verific			Approval			
-/·· -		Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date		ion °C	Chief Eng	QC Inspector			
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CHECKED	APPROVED #	DRAWING NO.	REV. B SHEET 3 OF 4
DATE 05.1	2.05	STEP WELDMENT	SCALE 1:4



D3463-7 DRAG ARM

w/07007/

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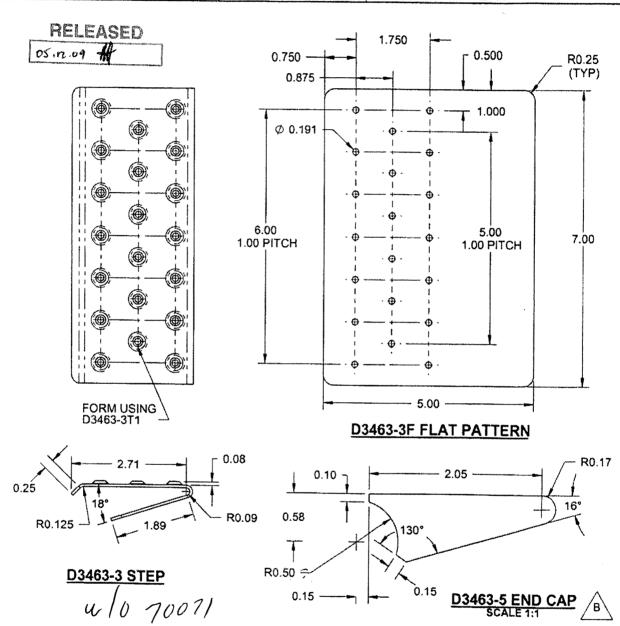
- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120) 2) FINISH: NONE 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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DATE 05 .1	12.05	STEP WELDMENT	SCALE 1:2			



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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